

# Work Order ID 58263

May 3, 2010 9:05:40 AM



Page 1

Item ID: D4094-1

Accept



Setup Start



Revision ID: PRELIM A

Item Name: Bracket

Stop



Start Date: 03/05/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: 10-3-03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4094

A

*Approved*

100

0.00



Bandsaw

Memo

0.00

*conf 10/05/04*

8

0

Jeaspa Bandsaw

Cut Blank 2.125" Long

110

0.00



HAAS 1

Memo

0.00

*B.A 10/05/05*

8

0

HAAS CNC vertical machine #1

Mill as per dwg anf Folio FA923

FOLIO REV: A

DWG REV: A

Deburr & Engrave as per Dwg

~~PRELIMINARY ISSUE~~

OK 10-05-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 58263

May 3, 2010 9:05:40 AM



Page 2

Item ID: D4094-1

Accept



Setup Start



Revision ID: PRELIM A2

Item Name: Bracket

Stop



Start Date: 03/05/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
						8	0		
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									

G-A 10/05/05

amk10/05/05

to Rev A Prelim  
Dry up Substoc

OK to RELEASE  
Rev A 10.05.20

QC APPROVAL

*[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 58263

May 3, 2010 9:05:40 AM



Page 3

Item ID: D4094-1	Accept		Setup	Start	
Revision ID: PRELIM A				Stop	
Item Name: Bracket					
Start Date: 03/05/2010	Start Qty: 8.00				
Required Date: 13/05/2010	Req'd Qty: 8.00				
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

1005-21  
MF  
10-5-21

POSITIVE RECALL  
EFFECTIVE 10-05-21 AUTH   
RELEASED 10-05-20 DATE   
1005-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May 3, 2010 9:05:48 AM

Page 1 / 1

Work Order ID: 58263



Parent Item: D4094-1



Parent Item Name: Bracket



Start Date: 03/05/2010

Required Date: 13/05/2010

Comments: IPP REV:A NEW ISSUE 10-04-21 JLM VERIFIED BY:DD

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M303B2.000X1.750		Purchased	No			100	f	4.2157	0.18			
												
303 BAR 2" X 1.750"												

Location

Loc Qty

Loc Code

MAT53

4.2157

113310

4.2157

1.44 *and* 10/05/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

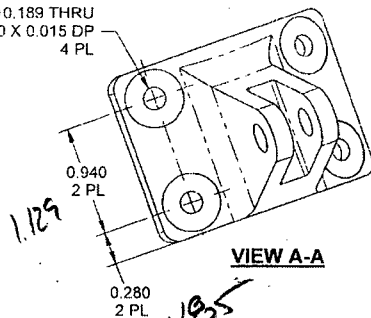
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

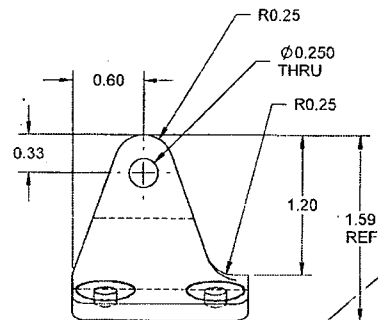
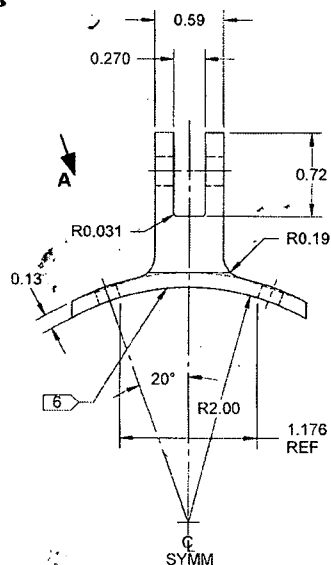
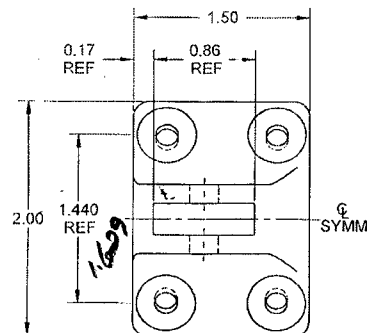
**NOTE:** Date & initial all entries



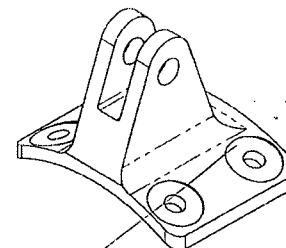
0.684  
 $\varnothing 0.189$  THRU  
 CBORE  $\varnothing 0.50 \times 0.015$  DP  
 4 PL



VIEW A-A



D4094-1 BRACKET



See Release  
 Rev. A.

NOTES:

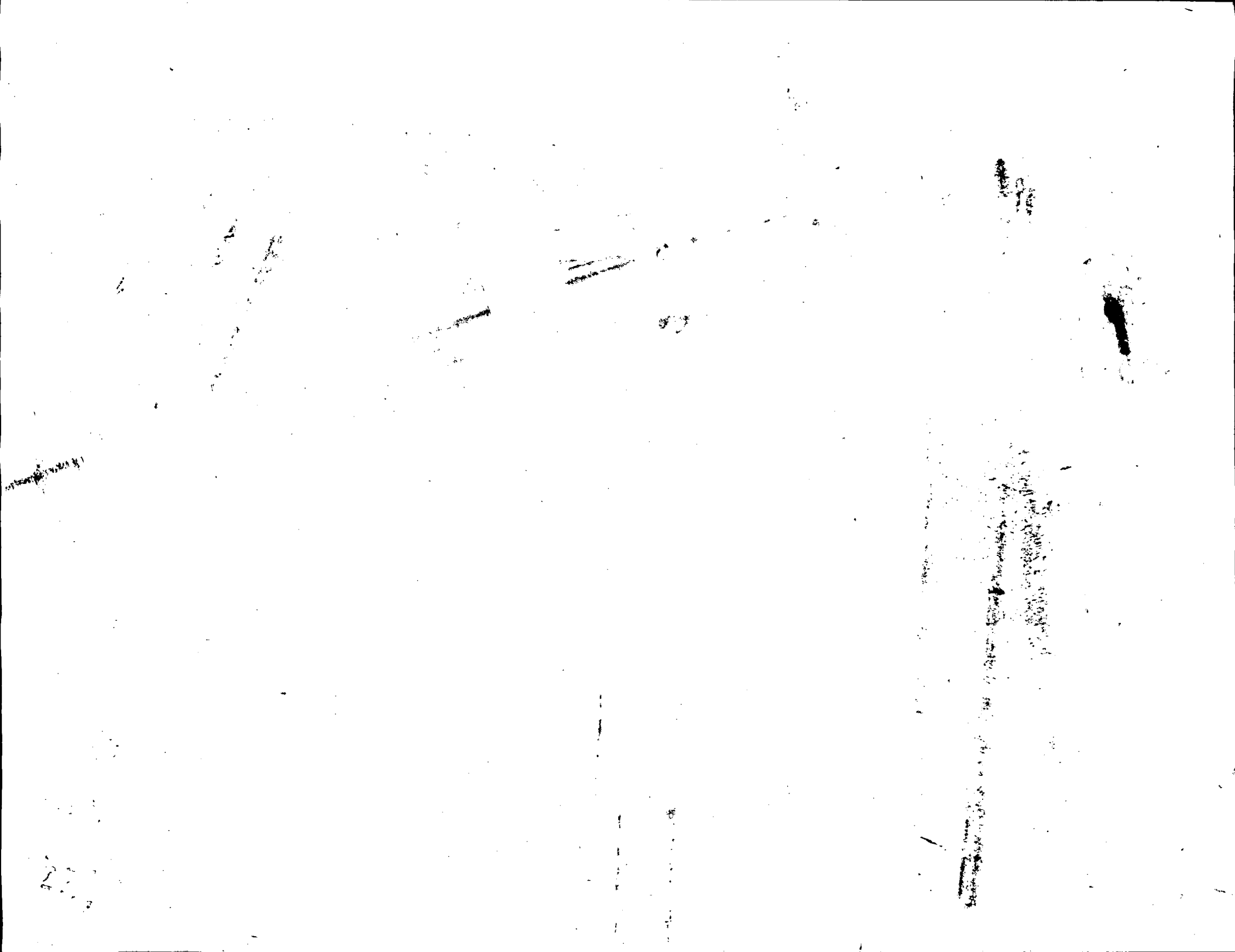
- 1) MATERIAL: AISI 303 BAR PER ASTM A582  
 REF. DART SPEC. M303B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH ERA P/N "41232-200-006-001" USING VIBRATING STYLUS
- 7) WEIGHT: 0.23 LBS

PRELIMINARY ISSUE

10.04.23

A		NEW ISSUE		DESCRIPTION		MB	10.04.07
REV.						BY	DATE
DESIGN				DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWN							
CHECKED				DRAWING NO.		REV. A	
MFG. APPR.				D4094		SHEET 1 OF 1	
APPROVED				TITLE		SCALE	
DE APPR.				BRACKET		NTS	
DATE				10.04.07			

COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.  
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS  
 NOT TO BE USED FOR ANY PURPOSES, INCLUDING REPRODUCTION, WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



DART AEROSPACE LTD		Work Order: 58263
Description: BRACKET		Part Number: 04094-1
Inspection Dwg: 4094	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.189	+ .005 / - .001	Ø 0.190	✓			
Ø .50 X Ø .015	+/- .030 / +/- .010	Ø .508 X .016	✓			
0.940	+/- .010	0.940	✓			
0.280	+/- .010	0.281	✓			
1.50	+/- .030	1.502	✓			
2.00	+/- .030	2.002	✓			
0.59	+/- .030	0.592	✓			
0.270	+/- .010	0.272	✓			
0.72	+/- .030	0.725	✓			
R 0.19	+/- .030	R 0.188	✓			
R 0.031	+/- .010	R 0.030	✓			
0.13	+/- .030	0.123	✓			
R 2.00	+/- .030	R 2.00	✓			
20°	+/- 1/2°	20°	✓			
0.33	+/- .030	0.330	✓			
0.60	+/- .030	0.599	✓			
R 0.25	+/- .030	R 0.250	✓			
Ø 0.250	+ .005 / - .001	Ø 0.254	✓			
R 0.25	+/- .030	R 0.250	✓			
1.20	+/- .030	1.201	✓			

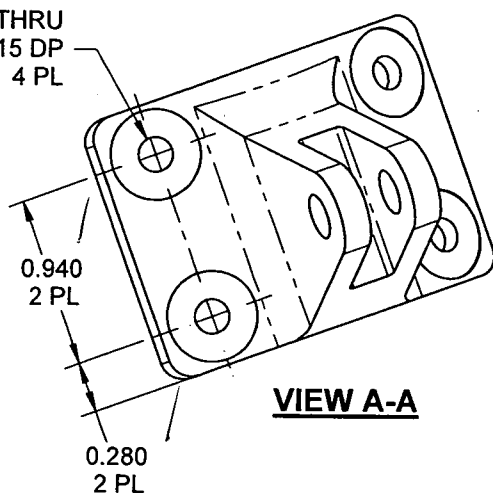
Measured by:	H.A
Date:	10/05/05

Audited by:	<i>[Signature]</i>
Date:	10/05/05

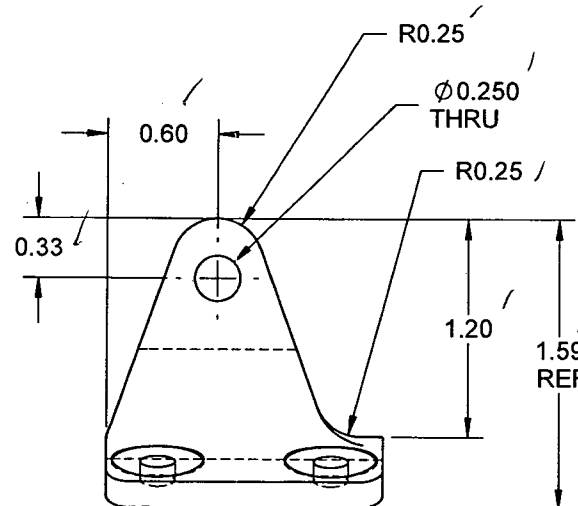
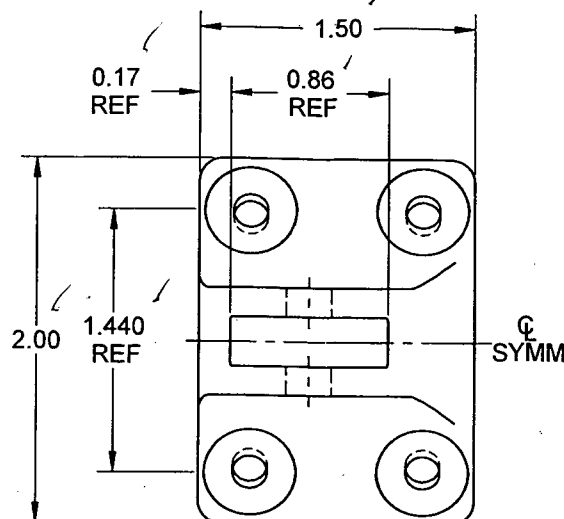
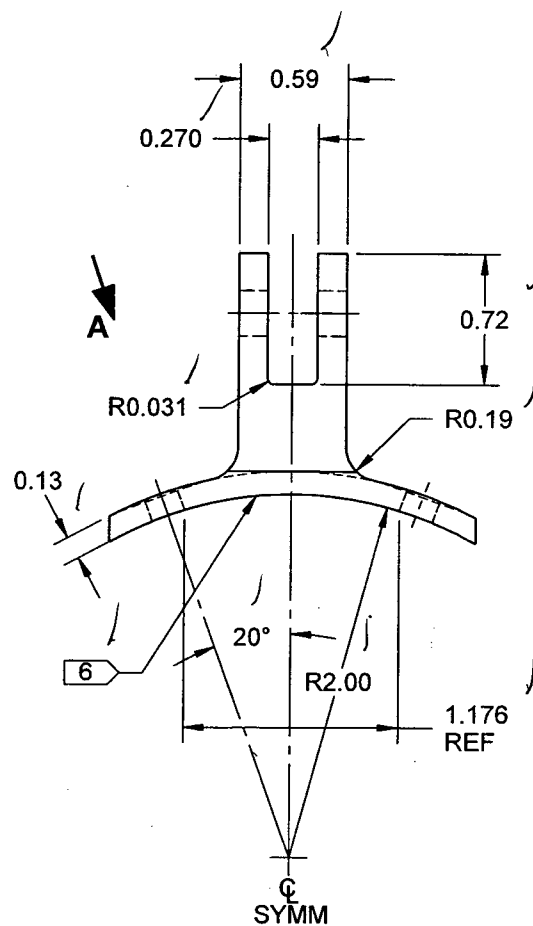
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

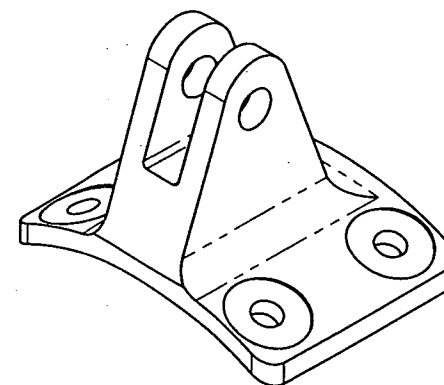
Ø0.189 THRU  
CBORE Ø0.50 X 0.015 DP  
4 PL



**VIEW A-A**



**D4094-1 BRACKET**



**NOTES:**

- 1) MATERIAL: AISI 303 BAR PER ASTM A582  
REF. DART SPEC. M303B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH ERA P/N "41232-200-006-001" USING VIBRATING STYLUS
- 7) WEIGHT: 0.23 lbs

**RELEASED**  
2010-05-20

A	NEW ISSUE	MB	10.04.07
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4094</b>	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
DATE	10.04.07	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	